

Date:
User:Tuesday, 01/05/2007 2:18:10 PM
Linda Lacelle

Process Sheet

Split
SB 07/05/14

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 31866	Part Number	: D35701
Estimate Number	: 12679	Drawing Number	: D3570 REV B <i>UE 07.06.07</i>
P.O. Number	: <i>NIA</i>	Project Number	: N/A
This Issue	: 01/05/2007 S.O. No. : <i>NIA</i>	Drawing Revision	: <i>B UE 07.06.07</i>
Prsht Rev.	: NC	Material	: <i>NIA</i>
First Issue	: <i>NIA</i> Type : SMALL / MED FAB	Due Date	: 13/05/2007
Previous Run	: 31866	Qty:	60 Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev:A New Issue 07-01-30 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.0746 sf(s)/Unit Total : 4.4730 sf(s)

6061-T6 .125 Sheet

Batch: *M103156*

Grain must be Along 4.63

*SAD**07/05/04*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3570

Dwg Rev: *B*Prog Rev: *B*

2-Deburr if necessary

*SAD**07/05/04**MTF**07-05-07**60**PTD*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD**07/05/04**60*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*SB 07.06.07**60*

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D3570

*SB 07/05/04**38*

Date: Tuesday, 01/05/2007 2:18:10 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31866

Part Number: D35701

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut excess materials per Dwg D3570.

3-Drill as per Dwg D3570

FF 07-05-11 60

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job n 38

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-06-13 38

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 101601 BR 07-06-13 38

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/06/14 (32) + 6 GA

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: 51 243A

07/06/14 (32) + 6 GA

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/14 38

Job Completion



07/06/14

Date: Tuesday, 4/17/2007 11:13:40 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET *Reprint*
 Job Number : 31866
 Estimate Number : 12679
 P.O. Number :
 This Issue : 4/17/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D35701
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3570 UNDER REVIEW *Rev B*
 Previous Run : 31478 Drawing Revision : U/R
 Material :
 Due Date : 5/12/2007 Qty: 60 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-01-30 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation Description :

1.0 M6061T6S125 6061-T6 125 Sheet



Comment: Qty.: 0.0746 sf(s)/Unit Total : 4.4730 sf(s)
 6061-T6 125 Sheet
 Batch: _____

Grain must be Along 4.63"**

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3570
 Dwg Rev: _____
 Prog Rev: _____

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3570

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/05/14	5	W/O Split	SB	07/05/14	28		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/04	2.0	P. Machine Malfunction Scrap One Part		Scrap & destroy and replace	SAD 07/05/04	<i>[Signature]</i> 07/05/04		<i>[Signature]</i> 07/05/04

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31866

Part Number: D35701

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock
Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

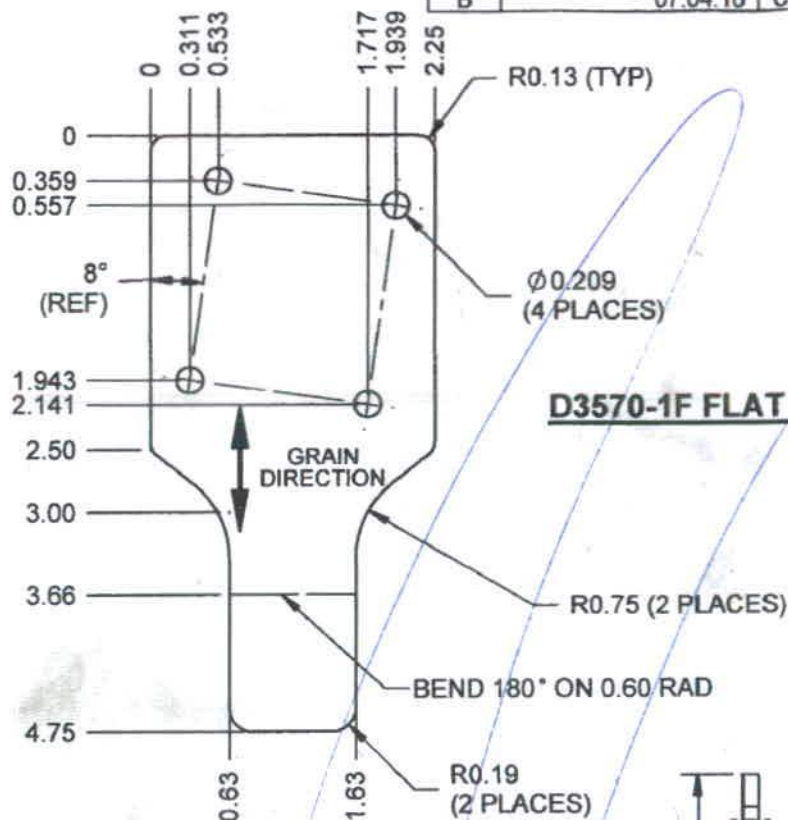
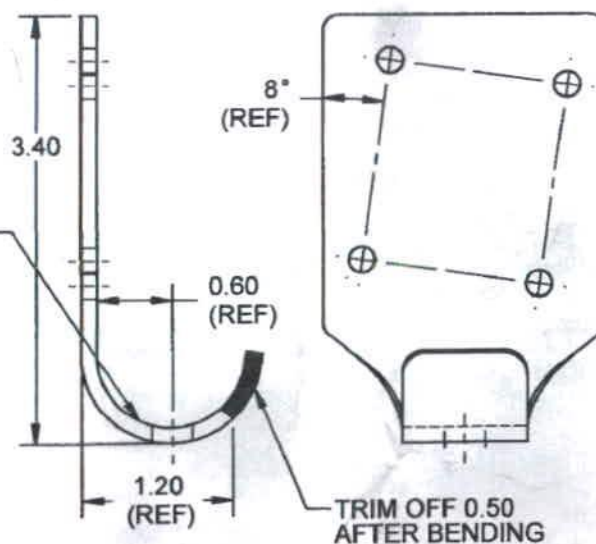
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>A</i>	DRAWING NO. D3570	REV. B SHEET 1 OF 1
DATE 07.04.16	TITLE BRACKET		SCALE 2:3
REV A	DATE 07.02.07	DESCRIPTION NEW ISSUE	
B	07.04.16	CHANGE BEND RAD TO 0.60 FROM 0.50	

**D3570-1F FLAT PATTERN****D3570-1 BRACKET SHOWN
(MAKE FROM D3570-1F)****D3570-2 BRACKET OPPOSITE
(MAKE FROM D3570-1F)****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.125" THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3570-1/-2" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

FIRST ARTICLE INSPECTION CHECKLIST

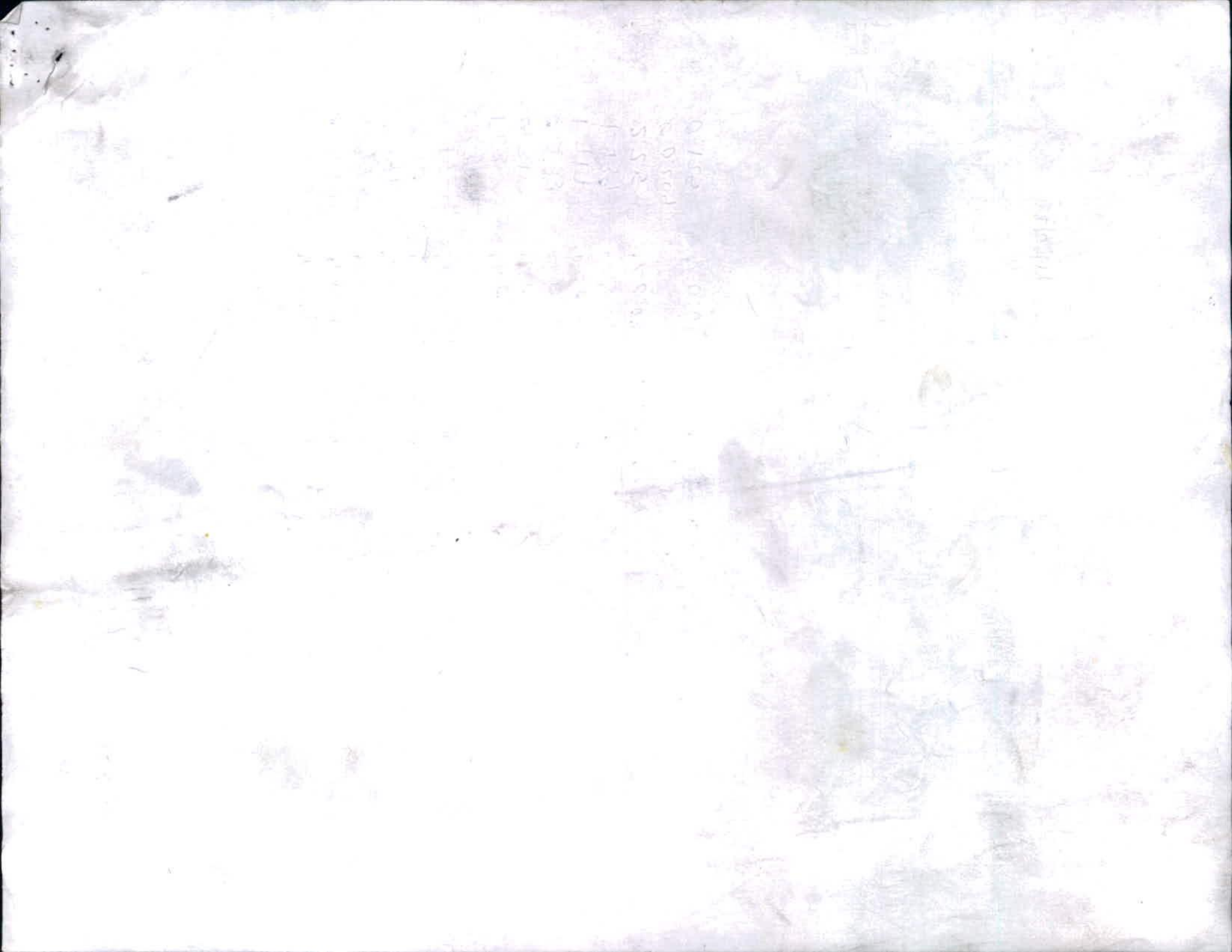
☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.359	± 0.010	0.359	✓		Vern	
0.557	± 0.010	0.559	✓		Vern	
1.943	± 0.010	1.942	✓		Vern	
2.141	± 0.010	2.139	✓		Vern	
2.50	± 0.030	2.50	✓		Vern ^{vertical}	
4.75	± 0.030	4.75	✓		Vern	
0.63	± 0.030	0.63	✓		height gauge	
1.63	± 0.030	1.62	✓		height gauge	
0.311	± 0.010	0.310	✓		Vern	
0.533	± 0.010	1.535	✓		Vern	
1.717	± 0.010	1.720	✓		Vern	
1.939	± 0.010	1.940	✓		Vern	
2.25	± 0.030	2.26	✓		Vern	
Ø 0.209	$\pm \begin{smallmatrix} 0.005 \\ 0.001 \end{smallmatrix}$	Ø 0.209	✓		Vern	
0.125	± 0.010	0.123	✓		Vern	

Approved by: JAN
Date: 07/05/04

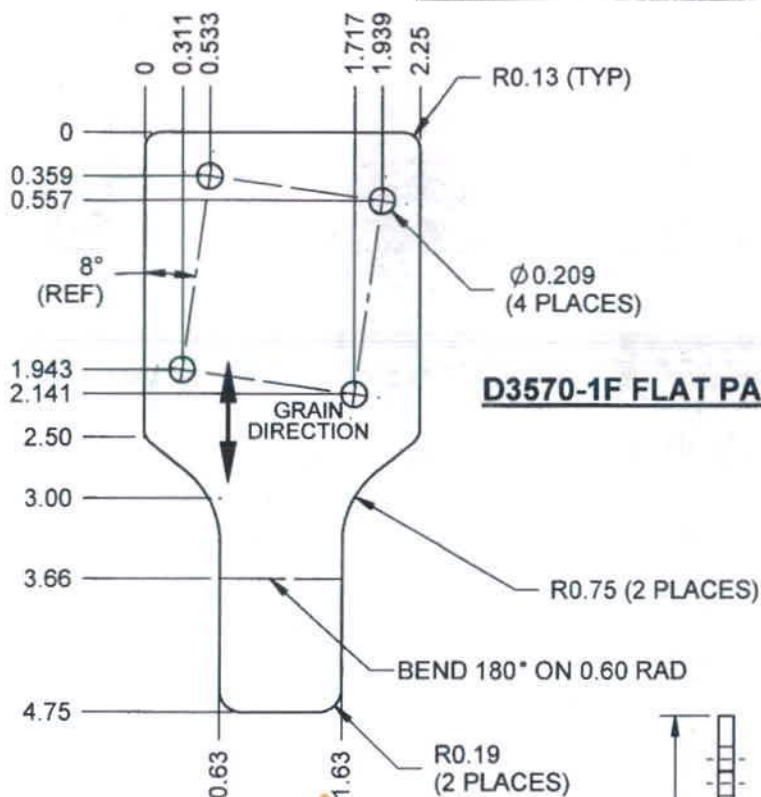
Audited by:	BB
Date:	07.05.04

Prototype Approval:	EUR
Date:	N/A



DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3570	REV. C SHEET 1 OF 1
DATE 07.06.01	TITLE BRACKET		SCALE 2:3
REV	DATE	DESCRIPTION	
A	07.02.07	NEW ISSUE	
B	07.04.16	CHANGE BEND RAD TO 0.60 FROM 0.50	
C	07.06.01	UPDATE DIMS FOR CLARITY	

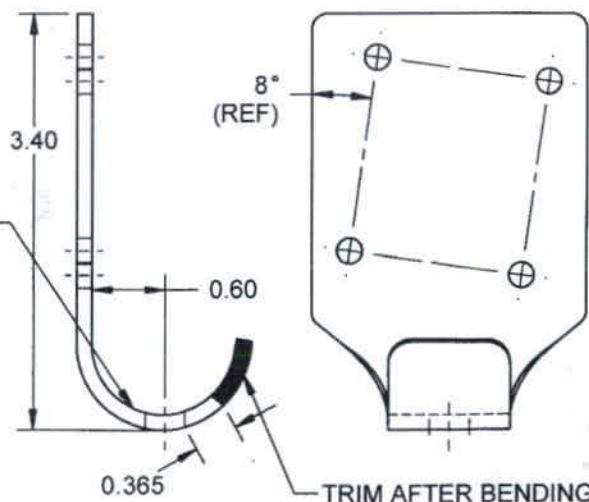
**RELEASED**07.06.01 *H*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. B31866

**D3570-1 BRACKET SHOWN
(MAKE FROM D3570-1F)**

**D3570-2 BRACKET OPPOSITE
(MAKE FROM D3570-1F)**

DRILL $\phi 0.328$ AFTER BENDING
CENTERED ON PART & ON BEND

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.125" THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3570-1/-2" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

